

# Work Order ID 86653

July-06-12 11:12:48 AM

**\*86653\***

Page 1

Item ID: D2362-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Support Bracket

Start Date: 7/06/12

Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 7/27/12

Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-07-11

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2362

Rev E1

100

0.00

**\*100\***

HAAS 1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

HAAS CNC vertical machine #1

1- Mill as per Folio FA800 Rev: AA & Dwg D2362 Rev: E1 2-Debur  
per dwg D2362

B.A 12/07/11

10

0

110

0.00

**\*110\***

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Quality Control

B.A 12/07/11

10

0

120

0.00

**\*120\***

QC

QC8- Inspect parts - second check

0.00

Memo

Quality Control

R. 2-7-11

10

0

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86653

July-06-12 11:12:48 AM

**\*86653\***

Page 2

Item ID: D2362-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Support Bracket  
 Start Date: 7/06/12 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 7/27/12 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*140*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>8:00</u> FINISH TIME: <u>8:30</u> OVEN TEMPERATURE: <u>320°F</u>								
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

W121841

MT  
10X 12/07/12

10X 12/07/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

July-06-12 11:12:48 AM

Page 3

HO

180

12/7/18P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 86653**

July-06-12 11:12:48 AM

**\*86653\***

Page 4

Item ID: D2362-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Support Bracket

Start Date: 7/06/12 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21 - Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

MF  
12-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

July-06-12 11:12:48 AM

Page 1

Work Order ID: 86653

Parent Item: D2362-3

Parent Item Name: Support Bracket

Start Date: 7/06/12

Required Date: 7/27/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: G00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2265 Step Bracket		Manufactured	No			160	Each	60.0000	1	4		8.2 12/07/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST488		60							
				→ 44114		60				10.0			
X D2397-1 Rubber Cushion		Manufactured	No		87864	160	Each	1.0000	1	4		(10) FF 12-07-17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1							
				72737		1							
X D2397-3 Rubber Cushion		Manufactured	No		87865	100	Each	0.0000	1	4		(10) FF 12-07-17	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 86653
<b>Description:</b> Step Support Bracket		<b>Part Number:</b> D2362-3
<b>Inspection Dwg:</b> D2362 <b>Rev:</b> E1		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	Ø0.258	✓		VERN	GA-01
3.074	+/-0.010	3.074	✓		"	"
0.34	+/-0.030	0.329	✓		"	"
0.77	+/-0.030	0.791	✓		"	"
1.500	+/-0.010	1.500	✓		"	"
1.000	+/-0.010	1.010	✓		"	"
0.80	+/-0.030	0.778	✓		"	"
1.200	+/-0.010	1.203	✓		"	"
1.28	+/-0.030	1.275	✓		"	"
1.000	+/-0.010	1.002	✓		"	"
0.75	+/-0.030	0.760	✓		"	"
1.88	+/-0.030	1.872	✓		"	"

<b>Measured by:</b> B.A.	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12/07/11	<b>Date:</b> 12-7-11	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF [Signature]	[Signature]



SHOP COPY

RETURN TO

ENGINEERING

UNCONT

SUBJECT

WITH

WORK ORDER

NO.

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
KE	#	D2362	SHEET 1 OF 3
DATE	TITLE		SCALE
98.12.04	STEP SUPPORT BRACKET		1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

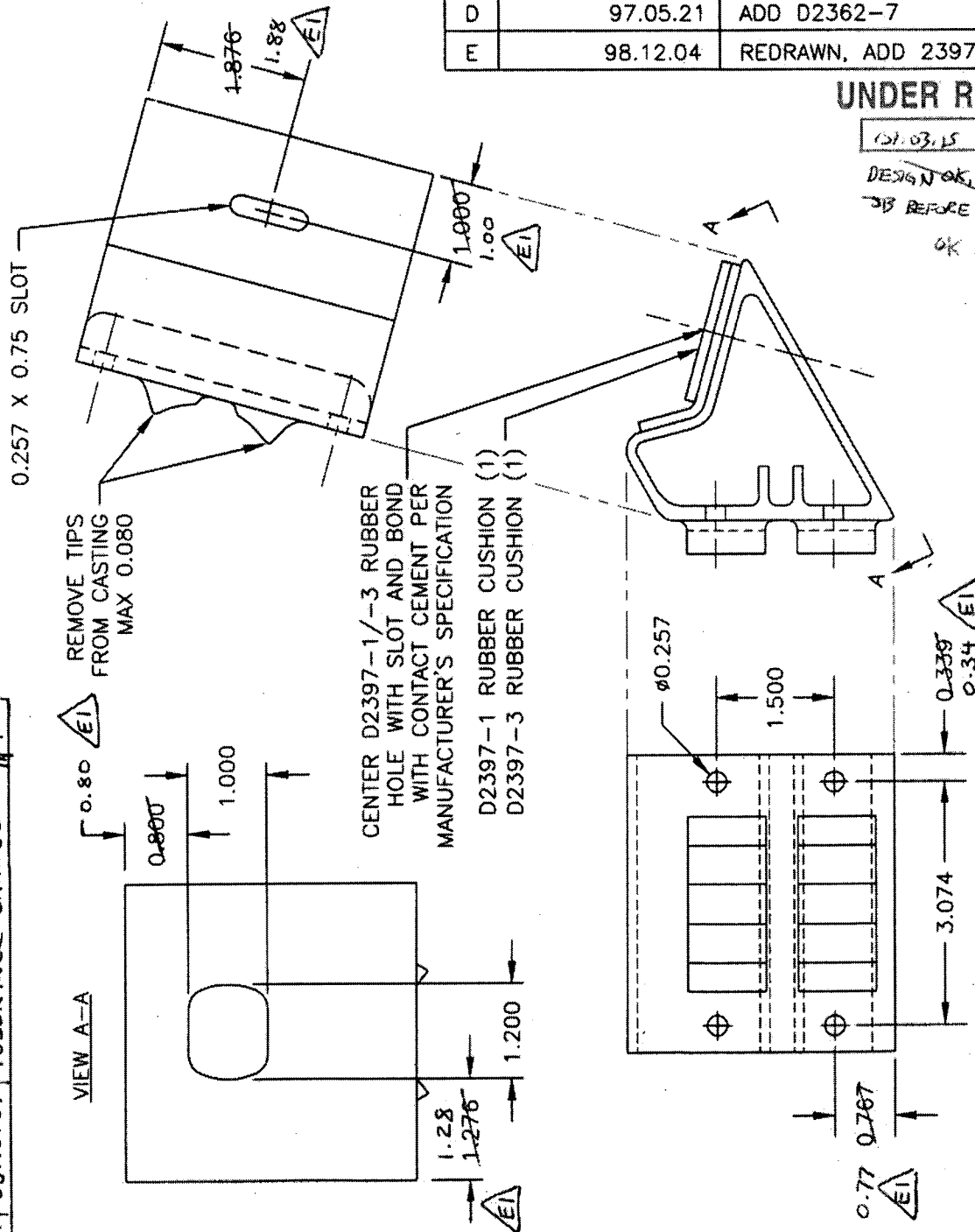
**RELEASED**  
98.12.14 KE

**UNDER REVIEW**

121.03.15 CP

DESIGN OK, BUT CHECK WITH  
JB BEFORE MANUFACTURE

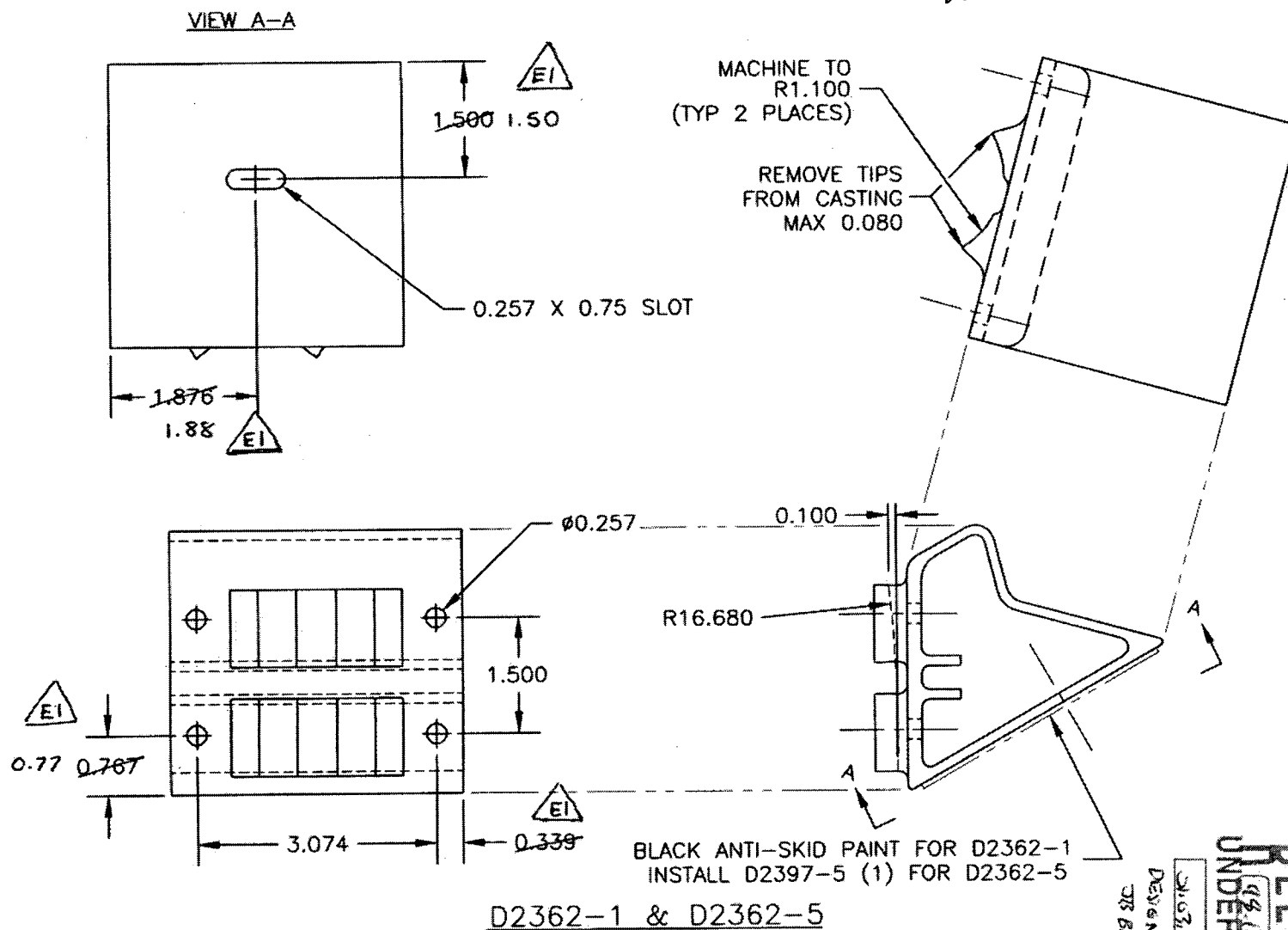
OK CP 04.11.09



NOTES:  
MAKE FROM D2265  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING  
RUBBER IN PLACE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY		DARI AEROSPACE LIB	
BW			HAMKESBURT, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E	
KE	JB	D2362	SHEET 2 OF 3	
DATE	TITLE		SCALE	
98.12.04	STEP SUPPORT BRACKET		1:2	



NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

118-12-14 KE  
UNDER REVIEW

5-  
303045 Q  
DENONOK, BUT AFTER WY  
DB BEING MANUFACTURE  
OK 4/24/09



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	MM	D2362
DATE	TITLE	SHEET 3 OF 3
98.12.04	STEP SUPPORT BRACKET	SCALE
		1:2

UNDER REVIEW

RELEASED  
98.12.14 KE

DESIGN OK BUT CHECK WITH  
DTS BEFORE MANUFACTURE

OK 9/24/04

86653

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

